

# Work Order ID 81280

**\*81280\***

Page 1

March-12-12 3:23:54 PM

Item ID: D350-578-011

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bearpaw

Start Date: 12/03/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 26/03/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/12 Tooling:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2432	Rev F3

100 DOCUMENT CONTROL 0.00

**\*100\***

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-578-011 CHG005

12/13/12

for MLJ 12-3-20  
(6)

160 Pick Kit 0.00

**\*160\***

Packaging

Memo

0.00

Packaging

12/3/20

(b)

170 QC4- 100% Inspect kits for completeness 0.00

**\*170\***

QC

Memo

0.00

Quality Control

12/13/12

(46)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 81280

**\*81280\***

Page 2

March-12-12 3:23:54 PM

Item ID: D350-578-011

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Bearpaw

Stop **\*NS2\***

Start Date: 12/03/2012 Start Qty: 6.00 **\*6\***

Cust Item ID:

Required Date: 26/03/2012 Req'd Qty: 6.00 **\*6\***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start **\*NR1\***

QC: Date: SPC (Y/N): Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

0.00

**\*180\***

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-578-011 Location: AG-13

*6/23/23 (6)*

190

QC21- Final Inspection - Work Order Release

0.00

**\*190\***

QC

Memo

0.00

Quality Control

*MLT 12/03/23*

*10-03-23*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

March-12-12 3:23:57 PM

Page 1

Work Order ID: 81280

**\*81280\***

Parent Item: D350-578-011

**\*D350-578-011\***

Parent Item Name: Bearpaw

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-01-02 JLM  
IPP Rev:B 08-01-09 Added Step 2 JLM Verified By:EC  
IPP Rev:C 08-10-15 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-17A

Purchased

No

160

Each

470.0000

12

\*\*

2

**\*AN4-17A\***

Bolt

Location

Loc Qty

Loc Code

ST358

24

112314

8

116419

16

116704

0

ST359

446

118983

300

120187

146

D2182B

Manufactured

No

160

f

390.8542

2.5

\*\*

15

**\*D2182B\***

Rubber Cushion

Location

Loc Qty

Loc Code

ST410

390.85417

63413

1.6

66063

41.61817

73932

347.636

Cut qty 6 at 5.00" long

D2274

Manufactured

No

160

Each

147.0000

12

72

**\*D2274\***

Radius Block

Location

Loc Qty

Loc Code

ST007

147

72121

32

78589

115

537 B 78233

19

12/13/20

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

March-12-12 3:23:57 PM

Page 2

Work Order ID: 81280

\*81280\*

Parent Item: D350-578-011

\*D350-578-011\*

Parent Item Name: Bearpaw

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 6.00

Required Qty: 6.00

D2432 Manufactured No

160 Each 0.0000

2

\*\*

\*D2432\*

206 (24") Bearpaw

D2438 Manufactured No

160 Each 86.0000

6

\*\*

\*D2438\*

Clamp

Location

Loc Qty

Loc Code

ST456

86

77038

8

78594

78

160 Each

417.0000

12

\*\*

D2529

\*D2529\*

Washer

Location

Loc Qty

Loc Code

ST010

417

66953

2

79221

275

79485

140

160 Each

3,831.000

12

\*\*

MS21042L4

\*MS21042L 4\*

Nut

Location

Loc Qty

Loc Code

ST300

3831

117441

51

117601

157

118451

133

119017

200

119075

3290

March-12-12 3:23:58 PM

Shop Packet Print

Page 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



# Picklist Print

March-12-12 3:23:58 PM

Page 3

Work Order ID: 81280

\*81280\*

Parent Item: D350-578-011

\*D350-578-011\*

Parent Item Name: Bearpaw

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 6.00

Required Qty: 6.00

NAS1149D0463J

Purchased

No

160

Each

1,492.000

24

144

\*NAS1149D0463.I\*

Washer

\*\*

12/3/20

## Location

## Loc Qty

## Loc Code

ST298

1492

116805

0

118384

31

119097

169

120644

1292

144

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

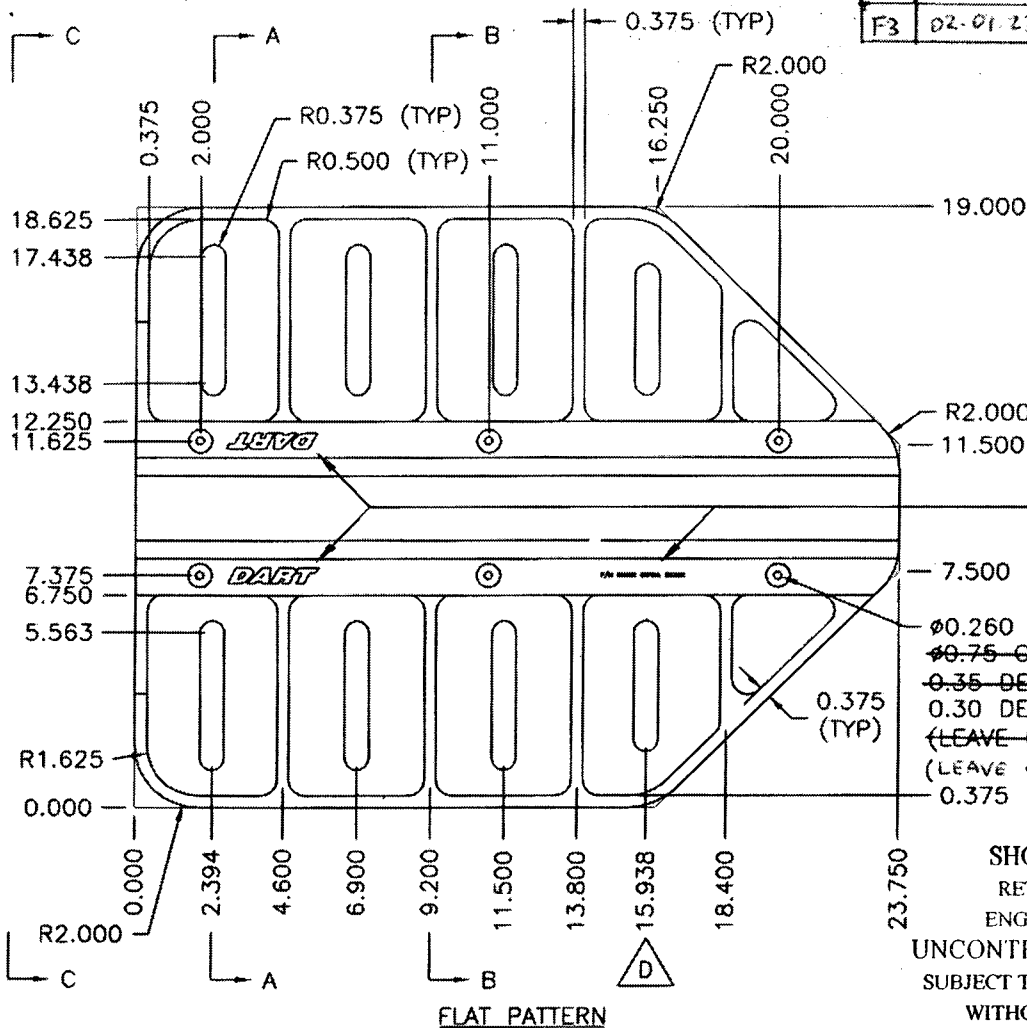
NOTE: Date & initial all entries

F1	99.03.03	ADD DEO 9143
F2	01.03.28	Ø0.93 WAS Ø0.75 <del>RF</del>
F3	02.01.23	CLARIFY BORE DIMS <del>RF</del>

RELEASED  
98.06.17 KE



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
KE	KE	
CHECKED	APPROVED	DRAWING NO.
MM	KE	D2432
DATE	TITLE	REV. F
98.05.12	BEARPAW	1 OF 2
A	95.10.31	NEW ISSUE
B	96.01.24	RE-DESIGN
C	96.03.26	CHANGE BORE AND C'BORE DEPTH
D	96.06.04	MOVE SLOT
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N



ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 81280 ML5  
12/03/12

EFFECTIVE	DEOS
9143	

D2432F: FLAT BEARPAW  
D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

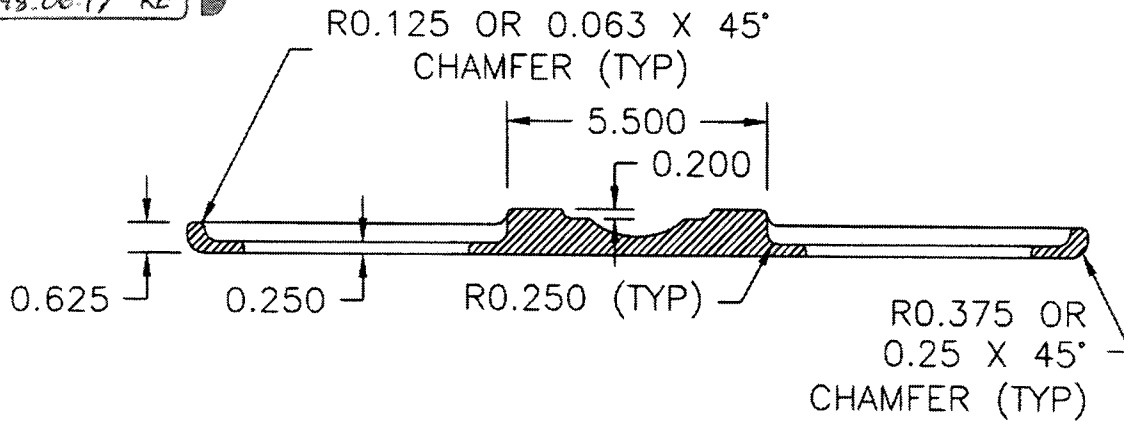
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

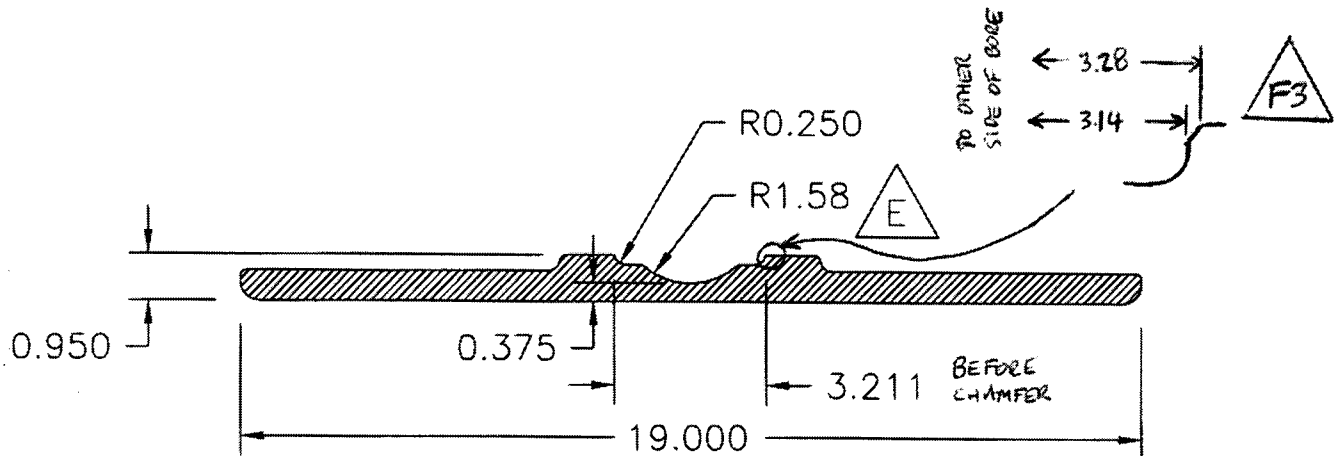


DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED MK	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12	TITLE BEARPAW		SCALE 1:4

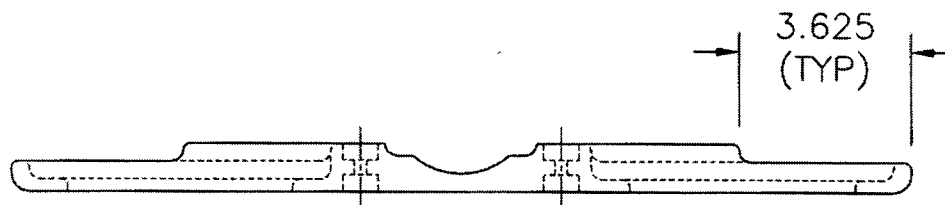
RELEASED  
98-06-17 KE



SECTION A-A



SECTION B-B



SECTION C-C

08212

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries